



Dart Aerospace Ltd.
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Canada

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D3391-023
Job Sheet 176044



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/23/18	0.00	0.00	Start Up Skidtubes-1		J.G
100	Skidtubes	1 pcs		5/23/18	0.88	2.11	Skidtubes-4		J.G
110	QC	1 pcs		5/23/18	0.00	0.00	QC5		PD 18-06-23
120	HandFinish	1 pcs		5/23/18	0.00	0.38	HandFinish1		BE 18-07-02
130	QC	1 pcs		5/23/18	0.00	0.00	QC7-2		BE
140	Skidtubes	1 pcs		5/23/18	0.00	2.11	Skidtubes-4		J.G
150	QC	1 pcs		5/23/18	0.00	0.00	QC5		BE
160	Skidtubes	1 pcs		5/23/18	0.00	2.11	Skidtubes-4		BE J.G
170	QC	1 pcs		5/23/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs		5/23/18	0.00	0.00	QC5		9-89 38
185	HandFinish	1 pcs		5/23/18	0.00	0.38	HandFinish2		SA 18-07-25
191	SprayPaint	1 pcs		5/23/18	0.00	0.91	Spray Paint		AS AUG 02 2018
192	Outsource	1 pcs		5/23/18			ATE003-VC		N/R
193	Packaging	1 pcs		5/23/18	0.00	0.00	Packaging2		W 18-08-20
200	QC	1 pcs		5/23/18	0.00	0.00	QC14		W 18-08-20
230	HandFinish	1 pcs		5/24/18	0.00	0.38	HandFinish4		W 18-08-20
240	QC	1 pcs		5/24/18	0.00	0.00	QC5		W 18-08-20
250	Packaging	1 pcs		5/24/18	0.00	0.00	Packaging3-1		W 18-08-20
260	QC21-SA	1 Ea		5/24/18	0.00	0.00	QC21		W 18-08-20

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1

Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021 BATCH: BE 18-07-02 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker, ***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG*** Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe

140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: A-03-06 batch#: M138874
 NOTE: ENSURE WEB IS INSERTED IN AFT END OF TUBE
 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush A/R 138834
 185 - Re-alodine
 191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 138862 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 138886
 230 - 1-Install Inserts as per Dwg

065047

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skidtube Extrusion	1 Ea (1 ea)	90-Start up Operation	163253
D3389-1	Web	1 Ea (1 ea)	140-Skidtubes	5063885
D3681-1	Spacer	5 Ea (5 ea)	160-Skidtubes	5084724
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	5003274
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	5002403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	59	0
140-Skidtubes	D3389-1	1	2	0
160-Skidtubes	D3681-1	5	248	0
230-HandFinish	ALS4-1032-130	20	14,777	0
	D3591-1	2	55	0

Part Specifications



Container No: S075913



Part: D3391-023

Job No: 176044

Serial No/Batch: S075913

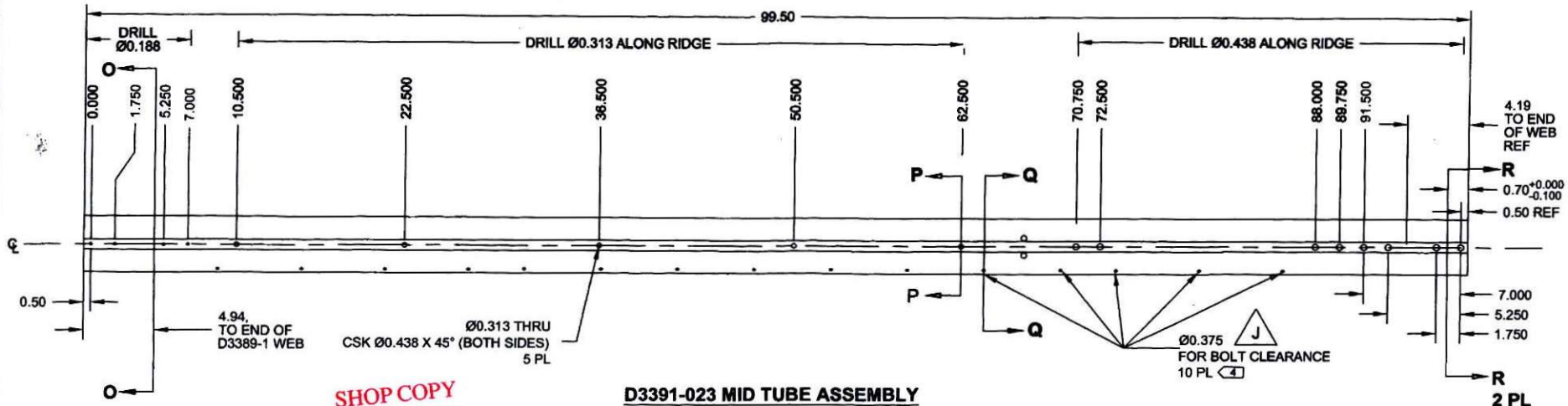
Revision: J

Inspector:

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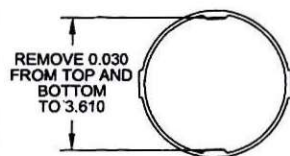
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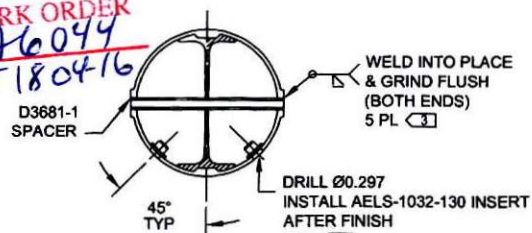


D3391-023 MID TUBE ASSEMBLY

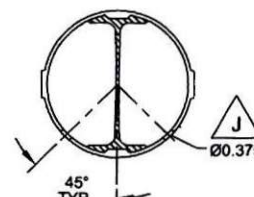
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NO. 176044
MLJ 180416



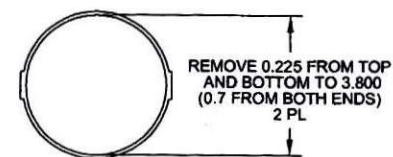
SECTION O-O
SCALE 2X



SECTION P-P
SCALE 2X



SECTION Q-Q
SCALE 2X



SECTION R-R
SCALE 2X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHOEVER SUPPLIES OR THE EXPRESS OR IMPLIED THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2016-04-28